

April 14, 2010 11:37:22 AM



**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

**Approvals:**

### Process Plan:

Date: 10-4-14 Tooling:

Date:

Run Start

**QC:**

**Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_

Date:

**Stop**

---

B 10-5-6

1-Cut as per Dwg D3191 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Debur  
if necessary

1-Cut as per Dwg D3191 ☐ Dwg Rev: B ☐ Prog Rev: B ☐ 2-Debur  
if necessary

6061 . 063

HB 10-5-6

HB 10-5-6

## Memo

Solutio

415

## Quality Control

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries

# Work Order ID 57747

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Item ID:	D3191-3	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Backer Plate					
Start Date:	14/04/2010	Start Qty: 6.00		Cust Item ID:		
Required Date:	22/04/2010	Req'd Qty: 6.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00				(15)		10-56	
140  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00				15			
150  Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 1112588 Memo START TIME: 7:00AM 7:30AM FINISH TIME: 3209	0.00  0.00				15			

OVEN TEMPERATURE:

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_






Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_


NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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<b>Item ID:</b>	D3191-3		<b>Accept</b>		<b>Setup</b>	<b>Start</b>	
<b>Revision ID:</b>							
<b>Item Name:</b>	Backer Plate					<b>Stop</b>	
<b>Start Date:</b>	14/04/2010	<b>Start Qty:</b> 6.00					
<b>Required Date:</b>	22/04/2010	<b>Req'd Qty:</b> 6.00		<b>Cust Item ID:</b>			
<b>Reference:</b>				<b>Customer:</b>			

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							$\Rightarrow$ m-k 10/05/07 (15X)
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>57042</u>  Memo	0.00  0.00							Per 10/10 (10)
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							10/05/10

PL 10-5-10  
(15)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 1

Work Order ID: 57747

Parent Item: D3191-3

Parent Item Name: Backer Plate

Comments: IPP Rev:A 08-08-01 new issue DD verified by:EC  
IPP Rev:B 09-01-28 rev.B as per dwg DD verified by:EC

Start Date: 14/04/2010

Required Date: 22/04/2010

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	175.0000	0.8147	2.1		
6061-T6 .063 Sheet												

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

MAT21

175

113608

175

112939

112939

15

1810-5-6

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 57247  
P10-4-14

RELEASED  
09/01/15 NW

**NOTES:**

- 1) MATERIAL: 6061-T6 ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GREY-SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3191-X" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: -1: 0.10 lbs  
-3: 0.10 lbs  
-5: 0.09 lbs

B	TRANSFERRED TO "B" SIZE DRAWING AND UPDATED TO CURRENT STANDARDS. ADDED -5. REASON: SEE NCR 08-110.		AJS	08.11.26
A	NEW ISSUE		CP	03.05.27
REV.	DESCRIPTION		BY	DATE
DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA		
DRAWN	AJS			
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3191	SHEET 1 OF 2	
APPROVED		TITLE	SCALE	
DE APPR.		BACKER PLATE	NTS	
DATE	08.11.26	<small>COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>		

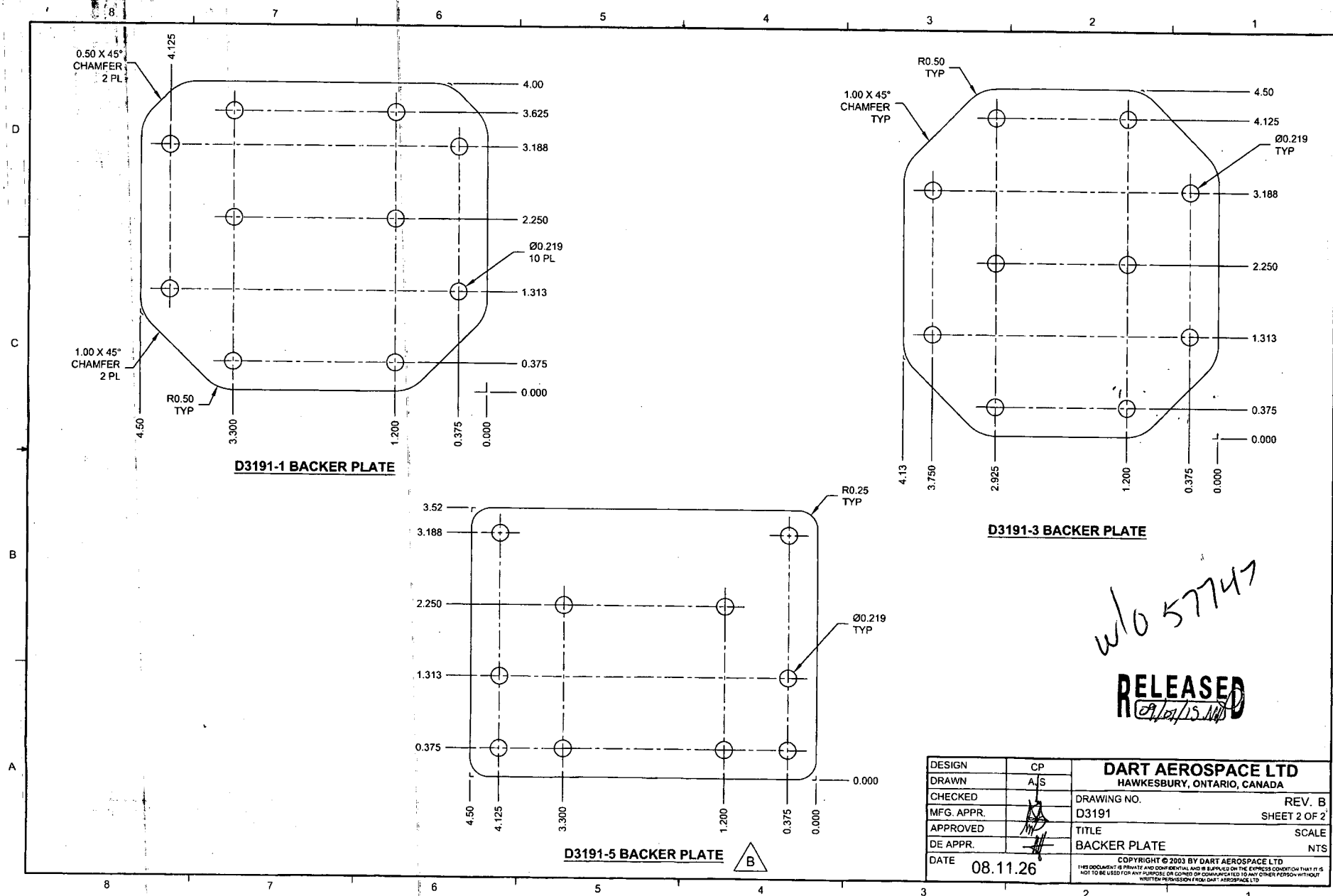
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



w/o 57747

**RELEASED**  
29/01/15 MJD

DESIGN	CP	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3191	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BACKER PLATE	NTS
DATE	08.11.26	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS MARKED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCE OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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